

Work Order ID 78232

78232

Page 1

January-02-12 3:53:08 PM

Item ID: D3580-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Joggle Bracket
 Start Date: 02/01/2012 Start Qty: 60.00 ***60*** Cust Item ID:
 Required Date: 16/01/2012 Req'd Qty: 60.00 ***60*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/01/02 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3580 | Rev B |

| | | | | | | | | | |
|--------------|----------------|------|--|--|--|--|--|--|--|
| 100 | FLOW WATER JET | 0.00 | | | | | | | |
| *100* | | | | | | | | | |
| Waterjet | Memo | 0.00 | | | | | | | |

FLOW CNC Waterjet
304.05C
 1-Cut as per Dwg D3580
 Dwg Rev: B
 Prog Rev: B
 2-Deburr if necessary

| | | | | | | | | | |
|--------------|---|------|--|--|--|--|--|--|--|
| 110 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |

Quality Control

| | | | | | | | | | |
|--------------|-----------------------------------|------|--|--|--|--|--|--|--|
| 120 | QC8- Inspect parts - second check | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |

Quality Control

B12-1-9

102

B12-1-9

Sizelock

Count
 102

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|-------------|--------------|---------------|---------------|------------------|----------------|
| 130 | | 0.00 | | | | | | | |
| *130* | Small Fab | | | | | (102) | | | |
| Small Fab | Memo | 0.00 | | | | | | | |
| Small Fab | Bend as per dwg D3580 using 1/8" offset die | | | SP 12/01/24 | | | | | |
| 140 | | 0.00 | | | | | | | |
| *140* | QC5- Inspect part completeness to step on W/O | | | | | | | | |
| QC | Memo | 0.00 | | 8/22/01/25 | | (102) | | | |
| Quality Control | | | | | | | | | |
| 150 | | 0.00 | | | | | | | |
| *150* | Identify as per dwg & Stock Location: <u>ST 55</u> | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | (102) | | | SP 12-01-25 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

12/1/26
12-01-24
102

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January-02-12 3:53:11 PM

Page 1

Work Order ID: 78232

78232

Parent Item: D3580-1

D3580-1

Parent Item Name: Joggle Bracket

Start Date: 02/01/2012

Required Date: 16/01/2012

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP Rev :A New Issue 07.06.25 EC
IPP Rev:B Removed Powder Coat 07-07-11 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M304S18GA

Purchased

No

100

sf

365.5050

0.01

0.631579

1.

M304S18GA

B12-1-9

304/316 .050 Sheet

Location

Loc Qty

Loc Code

MAT020

365.505

113062

0.005

119032

152.3

119188

0.2

119383

96

119766

117

113062

119188

119383

(102)

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

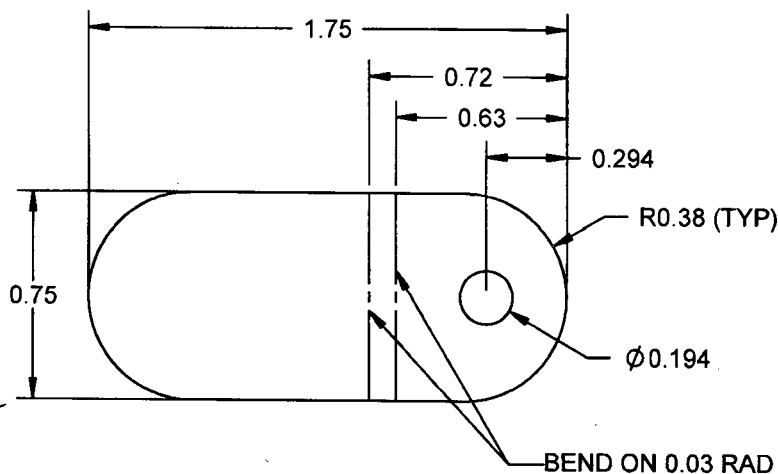


| | | | |
|----------------------|--------------------------------|---|------------------------|
| DESIGN <i>LE</i> | DRAWN BY <i>CB</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>LE</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3580 | REV. B SHEET 1 OF 1 |
| DATE 07.07.09 | | TITLE JOGGLE BRACKET | SCALE 3:2 |
| REV | DATE | DESCRIPTION | |
| A | 07.05.15 | NEW ISSUE | |
| B | 07.07.09 | REMOVE POWDER COAT | |

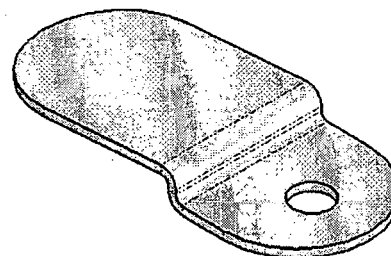
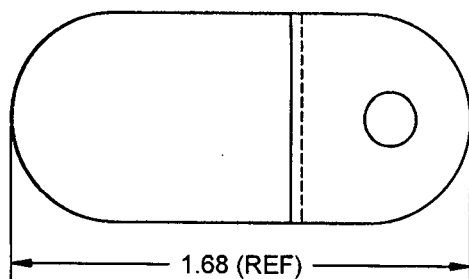
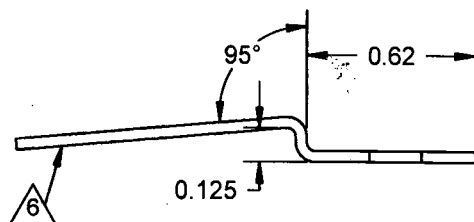
RELEASED

07.07.09 *[Signature]*

SHOP COPY
REVISION
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO A
WITH
WORK ORDER
NO. *78232 M.C.J*
12/01/02



D3580-1F FLAT PATTERN



D3580-1 JOGGLE BRACKET

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK)
PER MIL-S-5019 (REF DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3580-1" USING FINE POINT PERMANENT INK MARKER
ON THE UNDERSIDE OF THE PART AS INDICATED

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